

Date: Thursday, 5/4/2006 10:46:30 AM  
User: Kim Johnston

# Process Sheet

Customer : CU-DAR001 Dart Helicopters Services Drawing Name : SADDLE FITTING, AFT (OUTBOARD/INBOARD)  
Job Number : 26975  
Estimate Number : 10534  
P.O. Number : NIA Part Number : D2574  
This Issue : 5/4/2006 S.O. No. : NIA Drawing Number : D2574 REV E  
Prsht Rev. : NC Project Number : N/A  
First Issue : NIA Type : MACHINED PARTS Drawing Revision : E  
Previous Run : 26563 Material : NIA  
Written By : SEE 1A COMMENT BELOW Due Date : 5/25/2006 Qty: 12 Um: Each  
Checked & Approved By : JLM 06.05.04  
Comment : Est Rev: I As Per RevE 06-01-27 JLM

## Additional Product

Job Number:



Seq. #: Machine Or Operation: Description :

1.0 D6101005 7075-T7351 8.25X5.0X2.5



Comment: Qty.: 1.0000 Each(s)/Unit Total: 12.0000 Each(s)  
7075-T7351 8.25X5.0X2.5  
Make from D6101-005 billet for D2574  
Ensure that grain is along 5.00" length  
Batch No: B23946

2.0 HAAS1 HAAS CNC VERTICAL MACHINING #1



Comment: HAAS CNC VERTICAL MACHINING #1

Program Batch No. 26975 Double check by: JLM

1-Machine Step No 1 per Folio FA051 and inspect per attached Dimension Sheets  
2-Machine Step No 2 per Folio FA051 and inspect per attached Dimension Sheets  
3-Machine Step No 3 per Folio FA051 and inspect per attached Dimension Sheets  
4-Deburr and remove all machining marks  
5-Tumble to remove sharp edges.

En 06/06/21 x 8  
J.G 06/06/18

3.0 MILLING CONV. CONVENTIONAL MILLING MACHINE



Comment: CONVENTIONAL MILLING MACHINE

Machine keyway as per dwg D2573 & D2574

En 06/06/21 x 8

4.0 QC2 INSPECT PARTS AS THEY COME OFF MACHINE



Comment: INSPECT PARTS AS THEY COME OFF MACHINE

En 06/06/21 x 8

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes ☒ No ☐ DQA: DP Date: 06/06/26  
 QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Thursday, 5/4/2006 10:46:30 AM  
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## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: SADDLE FITTING, AFT (OUTBOARD/INBOARD)

Job Number: 26975

Part Number: D2574

Job Number:



Seq. #:

Machine Or Operation:

Description :

5.0

QC8

SECOND CHECK



Comment: SECOND CHECK

*Jul 06/06/21*

*8*

6.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Acid etch and Alodine as per QSI 005 4.1

*DL 06/06/22*

*(8)*

7.0

POWDER COATING

POWDER COATING



Comment: POWDER COATING

Powder Coat White Gloss (Ref: 4.3.5.1) as per QSI 005 4.3

*DL 06/06/22*

*(8)*

8.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT

*06/6/23*

*(8)*

9.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: *37480*

*06/6/23*

*(8)*

10.0

DC

DOCUMENT CONTROL



Comment: DOCUMENT CONTROL

Inspection Level 21

*06/06/26*

*(8)*

Job Completion



*Wade 26*

W/O:

## WORK ORDER CHANGES

DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:

## WORK ORDER NON-CONFORMANCE (NCR)

DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date &amp; initial all entries

<b>DART AEROSPACE LTD</b>	<b>Work Order:</b> 26975
<b>Description:</b> Saddle, Aft Inboard	<b>Part Number:</b> D2574
<b>Inspection Dwg:</b> D2574 Rev. E	<b>Page 1 of 1</b>

Inspect dimensions highlighted on inspection sheet drawing D2574 Rev. E and record below:

				Recorded Actual Dimensions				By	Date
Dim	Min	Max	Go/No Go Gauge	1	2	3	4		
A	0.438	0.443	DT8682	—	0.440	0.440	✓		
B	1.745	1.755		1.748	1.748	1.749	1.746		
C	3.495	3.505		3.498	3.498	3.501	3.498		
D	1.745	1.755		1.748	1.748	1.749	1.746		
E	7.990	8.010		7.998	8.002	8.002	8.003		
F	0.490	0.510		0.499	0.500	0.501	0.495		
G	0.257	0.262	DT8683		0.258	0.258	✓		
H	0.375	0.380	DT8684	—	0.376	0.376	✓		
I	0.490	0.510		0.501	0.498	0.499	0.498		
J	1.174	1.184		1.180	1.180	1.180	1.174		
K	0.558	0.578		0.567	0.568	0.568	0.563		
L	1.174	1.184		1.180	1.179	1.180	1.174		
M	1.365	1.375		1.370	1.371	1.372	1.367		
N	2.495	2.505		2.499	2.498	2.499	2.495		
O	4.119	4.129		4.123	4.121	4.121	4.123		
P	0.115	0.135		0.121	0.123	0.124	0.126		
Q	0.115	0.135		0.135	0.133	0.134	0.135		
R	0.240	0.260		0.248	0.247	0.245	0.251		
S	0.115	0.135		0.123	0.122	0.121	0.126		
T	0.178	0.198		0.188	0.188	0.188	0.188		
U	3.210	3.250		3.230	3.231	3.230	3.230		
V	0.230	0.250		0.237	0.238	0.237	0.238		
W	0.115	0.135		0.127	0.120	0.130	0.132		
X	0.307	0.312		0.312	0.309	0.310	0.310		
Y	0.760	0.765		0.760	0.761	0.761	0.763		
Z	0.352	0.372		0.372	0.368	0.368	0.368		
AA	0.470	0.530		0.500	0.500	0.500	0.500		
AB	0.615	0.635		0.626	0.624	0.623	0.620		
AC	0.053	0.073		0.063	0.063	0.063	0.063		
AD	0.240	0.260		0.245	0.246	0.245	0.245		
AE	1.500	1.520		1.512	1.513	1.514	1.505		
AF	0.115	0.135		0.135	0.134	0.132	0.135		
AG	0.240	0.280		0.273	0.270	0.271	0.260		
AH	0.240	0.260		0.245	0.241	0.240	0.245		
AI	2.000	2.020		CANNOT MEASURED					
AJ	0.023	0.043		0.033	0.033	0.033	0.033		
Accept/Reject									

Measured by: J.G	Audited by: E
Date: 06/05/25	Date: 06/06/21

Rev	Date	Change	Revised by	Approved
A		New Issue	RF	
B	02.09.27	Re-format; Added Rev. D	KJ	
C	02.10.11	Re-format; Added DT8682, DT8683, DT8684	KJ	
D	05.05.05	Added dimension AI	KJ/RF	
E	05.12.05	Added dimension AJ	KJ/JLM	

100

100

100

100

100

100

100

100

100

100

100

100

<b>DART AEROSPACE LTD</b>	<b>Work Order:</b>	26975
<b>Description:</b> Saddle, Aft Inboard	<b>Part Number:</b>	D2574
<b>Inspection Dwg:</b> D2574 Rev. E		Page 1 of 1

Inspect dimensions highlighted on inspection sheet drawing D2574 Rev. E and record below:

Dim	Min	Max	Go/No Go Gauge	Recorded Actual Dimensions				By	Date
				* 1	2	3	4		
A	0.438	0.443	DT8682	0.440	0.441	0.441	0.441		
B	1.745	1.755		1.747	1.748	1.745	1.747		
C	3.495	3.505		3.500	3.498	3.500	3.496		
D	1.745	1.755		1.747	1.748	1.745	1.747		
E	7.990	8.010		8.000	7.998	8.001	8.004		
F	0.490	0.510		0.497	0.491	0.496	0.498		
G	0.257	0.262	DT8683	0.258	0.259	0.259	0.259		
H	0.375	0.380	DT8684	0.376	0.377	0.377	0.377		
I	0.490	0.510		0.501	0.495	0.496	0.495		
J	1.174	1.184		1.179	1.178	1.176	1.175		
K	0.558	0.578		0.567	0.564	0.564	0.562		
L	1.174	1.184		1.179	1.178	1.176	1.175		
M	1.365	1.375		1.369	1.365	1.366	1.366		
N	2.495	2.505		2.497	2.495	2.496	2.496		
O	4.119	4.129		4.120	4.122	4.121	4.121		
P	0.115	0.135		0.124	0.124	0.123	0.125		
Q	0.115	0.135		0.122	0.135	0.135	0.135		
R	0.240	0.260		0.255	0.248	0.252	0.249		
S	0.115	0.135		0.130	0.124	0.124	0.126		
T	0.178	0.198		0.188	0.188	0.188	0.188		
U	3.210	3.250		3.230	3.230	3.230	3.230		
V	0.230	0.250		0.241	0.241	0.238	0.242		
W	0.115	0.135		0.125	0.122	0.125	0.126		
X	0.307	0.312		0.310	0.310	0.310	0.310		
Y	0.760	0.765		0.765	0.765	0.765	0.765		
Z	0.352	0.372		0.368	0.369	0.365	0.371		
AA	0.470	0.530		0.500	0.500	0.500	0.500		
AB	0.615	0.635		0.625	0.621	0.626	0.623		
AC	0.053	0.073		0.063	0.063	0.063	0.063		
AD	0.240	0.260		0.249	0.242	0.245	0.245		
AE	1.500	1.520		1.508	1.508	1.506	1.506		
AF	0.115	0.135		0.134	0.135	0.135	0.135		
AG	0.240	0.280		0.260	0.266	0.260	0.260		
AH	0.240	0.260		0.255	0.244	0.248	0.250		
AI	2.000	2.020		N/A	N/A	N/A	N/A		
AJ	0.023	0.043		0.033	0.030	0.030	0.030		
Accept/Reject									

Measured by: J.G. / EP	Audited by: JML
Date: 06/06/19 / 06/06/20	Date: 06/06/21

Rev	Date	Change	Revised by	Approved
A		New Issue	RF	
B	02.09.27	Re-format; Added Rev. D	KJ	
C	02.10.11	Re-format; Added DT8682, DT8683, DT8684	KJ	
D	05.05.05	Added dimension AI	KJ/RF	
E	05.12.05	Added dimension AJ	KJ/JLM	



<b>DART AEROSPACE LTD</b>	<b>Work Order:</b> 26975
<b>Description:</b> Saddle, Aft Inboard	<b>Part Number:</b> D2574
<b>Inspection Dwg:</b> D2574 Rev. E	<b>Page 1 of 1</b>

Inspect dimensions highlighted on inspection sheet drawing D2574 Rev. E and record below:

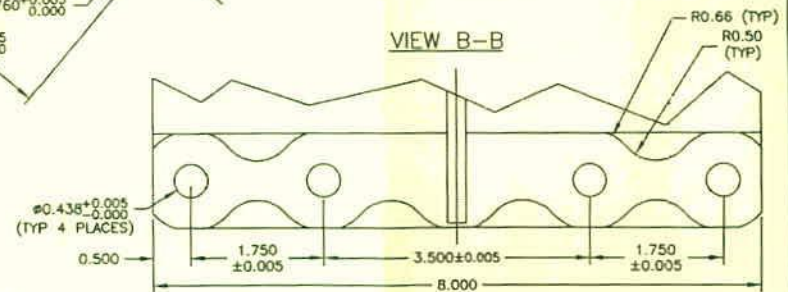
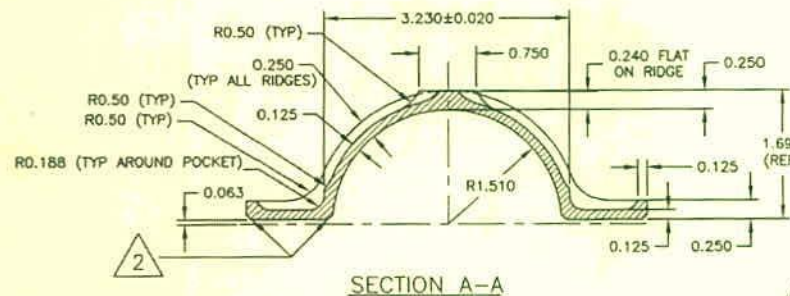
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B	1.745	1.755		1.746	1.746	1.746			
C	3.495	3.505		3.495	3.497	3.497			
D	1.745	1.755		1.746	1.746	1.746			
E	7.990	8.010		8.006	8.001	8.006			
F	0.490	0.510		0.497	0.496	0.498			
G	0.257	0.262	DT8683	0.259	0.259	0.259			
H	0.375	0.380	DT8684	0.377	0.377	0.377			
I	0.490	0.510		0.495	0.495	0.498			
J	1.174	1.184		1.176	1.176	1.176			
K	0.558	0.578		0.562	0.559	0.566			
L	1.174	1.184		1.176	1.176	1.176			
M	1.365	1.375		1.368	1.367	1.367			
N	2.495	2.505		2.497	2.496	2.496			
O	4.119	4.129		4.124	4.119	4.124			
P	0.115	0.135		0.122	0.125	0.125			
Q	0.115	0.135		0.135	0.135	0.135			
R	0.240	0.260		0.250	0.253	0.252			
S	0.115	0.135		0.121	0.121	0.124			
T	0.178	0.198		0.188	0.188	0.188			
U	3.210	3.250		3.230	3.230	3.230			
V	0.230	0.250		0.238	0.234	0.238			
W	0.115	0.135		0.121	0.126	0.122			
X	0.307	0.312		0.310	0.310	0.310			
Y	0.760	0.765		0.765	0.765	0.765			
Z	0.352	0.372		0.359	0.367	0.369			
AA	0.470	0.530		0.500	0.500	0.500			
AB	0.615	0.635		0.626	0.622	0.626			
AC	0.053	0.073		0.063	0.063	0.063			
AD	0.240	0.260		0.246	0.244	0.244			
AE	1.500	1.520		1.506	1.514	1.514			
AF	0.115	0.135		0.135	0.135	0.135			
AG	0.240	0.280		0.260	0.260	0.260			
AH	0.240	0.260		0.248	0.244	0.250			
AI	2.000	2.020		N/A	N/A	N/A			
AJ	0.023	0.043		0.030	0.030	0.030			
Accept/Reject									

Measured by: <i>ER</i>
Date: 06/06/21

Audited by: <i>ML</i>
Date: 06/06/21

Rev	Date	Change	Revised by	Approved
A		New Issue	RF	
B	02.09.27	Re-format; Added Rev. D	KJ	
C	02.10.11	Re-format; Added DT8682, DT8683, DT8684	KJ	
D	05.05.05	Added dimension AI	KJ/RF	
E	05.12.05	Added dimension AJ	KJ/JLM	<i>[Signature]</i>





05.2.06 

1 ENGRAVE PART AND BATCH NUMBER IN THIS AREA TO MAX DEPTH OF 0.010

2 CHAMFER 0.063" x 45° AROUND THIS SURFACE (TYPICAL 2 PLACES)

3 CHAMFER 0.063 x 45° ALL AROUND

4 CHAMFER 0.033 x 45° (SEE DETAIL C)

E

SHOP COPY  
RETURN TO  
ENGINEERING  
UNCONTROLLED COPY  
SUBJECT TO AMENDMENT  
WITHOUT NOTICE  
WORK ORDER  
NO. 26975

DETAIL C  
SCALE 2:1

THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL  
AND IS SUPPLIED ON THE EXPRESS CONDITION  
THAT IT IS NOT TO BE USED FOR ANY PURPOSE  
OR COPIED OR COMMUNICATED TO ANY OTHER  
PERSON WITHOUT WRITTEN PERMISSION FROM  
DART AEROSPACE LTD.

E	05.07.13	ADD CHAMFER ON RIDGE NOTE 4	
D	02.09.06	ADD RIDGES; TIGHTEN TOLERANCES	
C	99.10.22	INCRP. DEO 9123/9079/9102 ADD DIMENSIONS PER TSF A1177	
B	96.12.02	ADD GRAIN DIR., 0.438 WAS 0.425	
A	96.09.16	NEW ISSUE	
DESIGN	DRAWN BY	<b>DART</b>	<b>DART AEROSPACE LTD.</b> FARMERSBURG, ONTARIO, CANADA
DS	PH		
CHECKED	APPROVED	DRAWING NO. D2574	REV. E SHEET 1 OF 1
DATE		TITLE	SCALE
05.07.13		INNER AFT SADDLE	2:1

